

Work Order ID 78166

January-02-12 8:12:50 AM

78166

Page 1

Item ID: D412-630-034

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli Access Step RH Folding

Start Date: 02/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/02

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev M

100

100

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

S 12/02/13

M.L.J 12-2-13

110

110

Small Fab

Small Fab

Memo

0.00

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M119317

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: M114596

12/02/13 (S)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78166

January-02-12 8:12:50 AM

78166

Page 2

Item ID: D412-630-034

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli Access Step RH Folding

Stop

NS2

Start Date: 02/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/26/13

XS
RJ

130

130

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

8/26/13 (s)

140

QC4- 100% Inspect kits for completeness

0.00

Memo

8/26/13

XS
RJ

140

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78166

January-02-12 8:12:50 AM

78166

Page 3

Item ID: D412-630-034

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli Access Step RH Folding

Stop

NS2

Start Date: 02/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

Packaging

Packaging

0.00

12/21/14 SF

5

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-630-034

Location: W

PPP Rev: A

160

160

QC

QC21- Final Inspection - Work Order Release

0.00

12/21/14 JJ

Quality Control

Memo

0.00

12-02-14
(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-02-12 8:12:54 AM

Page 1

Work Order ID: 78166

78166

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 06-11-08 JLM
 IPP rev B ecn1019, added D2807-041 EC verified by:DD
 IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN310C8		Purchased	No		110	Each	22.0000	2	8				
---------	--	-----------	----	--	-----	------	---------	---	---	--	--	--	--

AN310C8

Nut

Location	Loc Qty	Loc Code
ST344	22	
118378	12	
119324	10	

--	--	--	--	--	--	--	--	--	--	--	--	--	--

\$10

AN3C21A		Purchased	No		110	Each	86.0000	2	8				
---------	--	-----------	----	--	-----	------	---------	---	---	--	--	--	--

AN3C21A

BOLT

Location	Loc Qty	Loc Code
ST352	86	
109148	2	
117514	34	
119798	50	

--	--	--	--	--	--	--	--	--	--	--	--	--	--

\$10

AN8C16		Purchased	No		110	Each	26.0000	2	8				
--------	--	-----------	----	--	-----	------	---------	---	---	--	--	--	--

AN8C16

Bolt

Location	Loc Qty	Loc Code
ST343	26	
106066	2	
118451	15	
119324	9	

--	--	--	--	--	--	--	--	--	--	--	--	--	--

\$10

--	--	--	--	--	--	--	--	--	--	--	--	--	--

*M120447 (K)**M111111**M111111**M111111*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-02-12 8:12:54 AM

Page 2

Work Order ID: 78166

78166
D412-630-034

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

D2012-107
D2012-107
Clevis

Manufactured No 110 Each 41.0000 1 4 **

Location	Loc Qty	Loc Code
ST004	41	
71602	3	
75057	38	

D2803-042
D2803-042
Bracket Assembly

Manufactured No 110 Each 4.0000 1 4 **

Location	Loc Qty	Loc Code
ST149	4	
75231	4	

D2804-042
D2804-042
Bracket Assembly

Manufactured No 110 Each 5.0000 1 4 **

Location	Loc Qty	Loc Code
ST150	5	
75095	2	
76183	3	

D2807-041
D2807-041
Door prop

Manufactured No 110 Each 39.0000 2 8 **

Location	Loc Qty	Loc Code
ST022	39	
60540	2	
68494	5	
73030	10	
73920	2	
77152	20	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-02-12 8:12:54 AM

Page 3

Work Order ID: 78166

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

78166
D412-630-034

Start Date: 02/01/2012 **Required Date:** 31/01/2012
Start Qty: 4.00 **Required Qty:** 4.00

D2813
D2813
Wade

D3395-1
D3395-1
Bushing

D3562-042
Step Assembly, RH
MS21043-3

MS21043-3

1988-19

*MS

Nut

Nut

Manufactured No 110 Each 17.0000

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST023	17	
69386	1	
75025	16	

Manufactured No 110 Each 33.0000

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST052	33	
71563	33	

Manufactured	No	110	Each	0.0000
		<i>B7816952**</i>		
Purchased	No	110	Each	1,469.000
		<i>**</i>		

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	72	
103691	72	
ST300	750	
119901	750	
ST301	647	
118077	2	
118614	441	
118686	30	
119758	174	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-02-12 8:12:54 AM

Page 4

Work Order ID: 78166

78166
D412-630-034

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

MS24665-302

Purchased

No

110

Each

81.0000

2

8

MS24665-302

Cotter Pin

**

MS24693-C280

Purchased

No

117460

110

Each

48.0000

2

8

MS24693-C280

Screw

**

NAS1515H3

Purchased

No

118612

110

Each

67.0000

6

24

NAS1515H3

Washer

**

NAS1515H5L

Purchased

No

119438

110

Each

194.0000

4

16

NAS1515H5L

WASHER

**

FG

Location

Loc Qty

Loc Code

103691

40

ST277

40

118614

154

119902

1

153

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

January-02-12 8:12:54 AM

Page 5

Work Order ID: 78166

78166
D412-630-034

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H8

Purchased No 110 Each 139.0000

4

16

NAS1515H8

Washer

**

2/12/13

AN44C7A

Purchased No 130 Each 42.0000

1

45

AN44C7A

Eyebolt

**

*45**45*

AN4C10A

Purchased No 130 Each 50.0000

1

4

AN4C10A

Bolt

**

119013 24
*111348 30**4**4*

AN4C15A

Purchased No 130 Each 109.0000

2

84

AN4C15A

Bolt

**

*112243**84*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-02-12 8:12:54 AM

Page 6

Work Order ID: 78166

78166
D412-630-034

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C6A

Purchased No

130 Each 488.0000

-1- 45

**

AN4C6A

Bolt

Location	Loc Qty	Loc Code
FG	4	
103344	4	
ST356	484	
116704	9	
118983	75	
119328	200	119328
119749	200	

AN5C15A

Purchased No

130 Each 66.0000

2

80

**

AN5C15A

Bolt

Location	Loc Qty	Loc Code
ST338	66	
118191	3	
118267	38	118267
119749	25	

D2806-1

Manufactured No

130 Each 14.0000

2

80

**

D2806-1

Bushing

Location	Loc Qty	Loc Code
ST022	14	
75047	14	75047

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-02-12 8:12:54 AM

Page 7

Work Order ID: 78166

78166
D412-630-034

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

D2806-3

Manufactured	No	130	Each	27.0000	2	70
--------------	----	-----	------	---------	---	----

**

D2806-3

Bushing

Location	Loc Qty	Loc Code
ST022	27	
75046	15	
76187	12	

75046

D2810-5

Manufactured	No	130	Each	7.0000	1	45
--------------	----	-----	------	--------	---	----

**

D2810-5

Strut

Location	Loc Qty	Loc Code
ST265	7	
52034	1	
75077	6	

75077

D3396-1

Manufactured	No	130	Each	12.0000	2	812
--------------	----	-----	------	---------	---	-----

**

D3396-1

Spacer

Location	Loc Qty	Loc Code
ST052	12	
75049	12	

75049

MS21043-4

Purchased	No	130	Each	1,275.000	4	160
-----------	----	-----	------	-----------	---	-----

**

MS21043-4

Nut

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST300	470	
118686	470	
ST301	765	
119309	269	
119546	496	

118686

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-02-12 8:12:54 AM

Page 8

Work Order ID: 78166

78166

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

130

Each

603.0000

3

+2/5

**

MS21043-5S
Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
101418	20	
ST300	158	
112314	158	112314
ST301	425	
116548	100	
118159	100	
119307	25	
119537	200	

NAS1515H4

Purchased

No

130

Each

101.0000

7

+2/5

**

NAS1515H4S
Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST277	101	
116169	3	
117460	1	
117735	3	
118078	48	
118612	46	

NAS1515H5

Purchased

No

130

Each

109.0000

7

+2/5

**

NAS1515H5S
Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
103286	20	
103691	20	
ST277	69	
103286	69	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

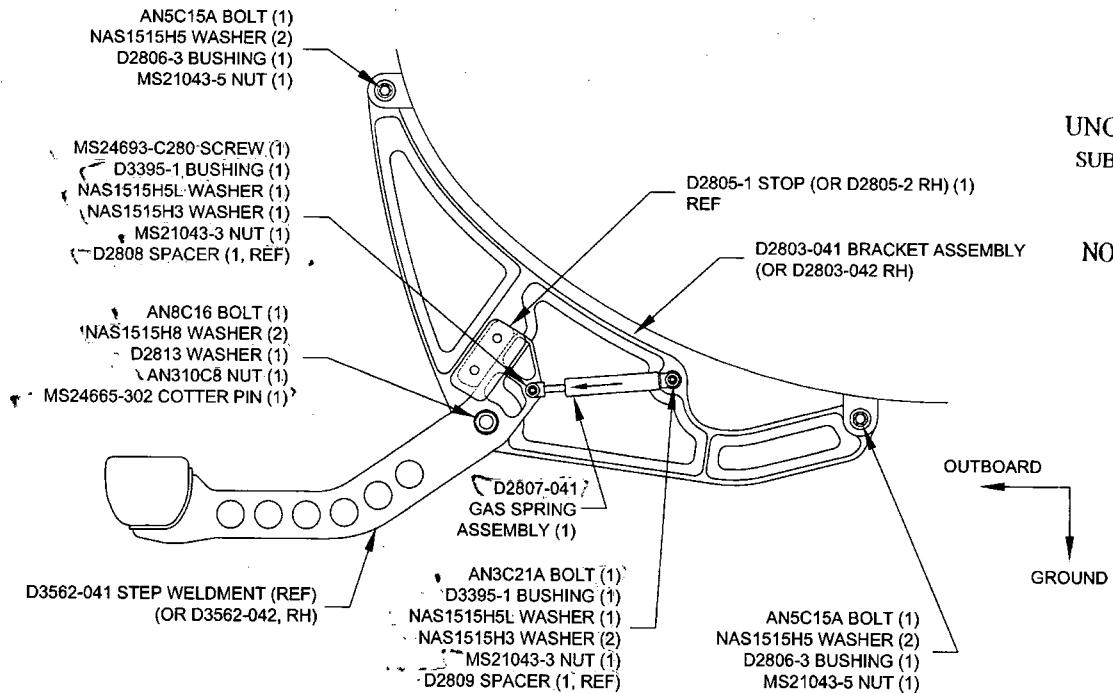
D412-630-033/-034 Heli-Access-Step™ Installation

FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

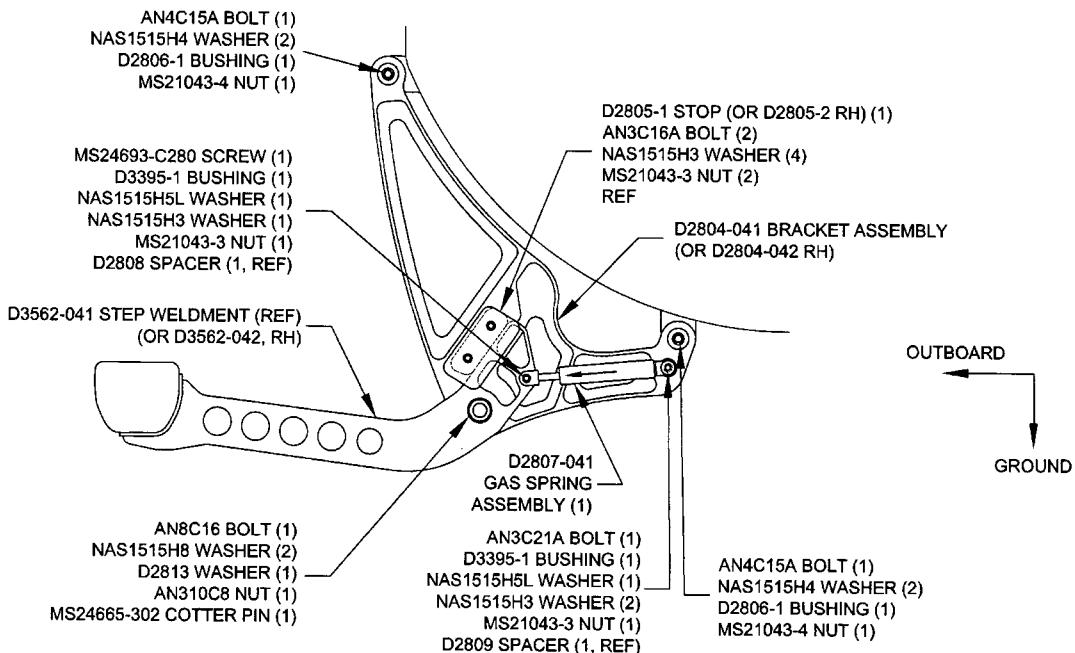


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

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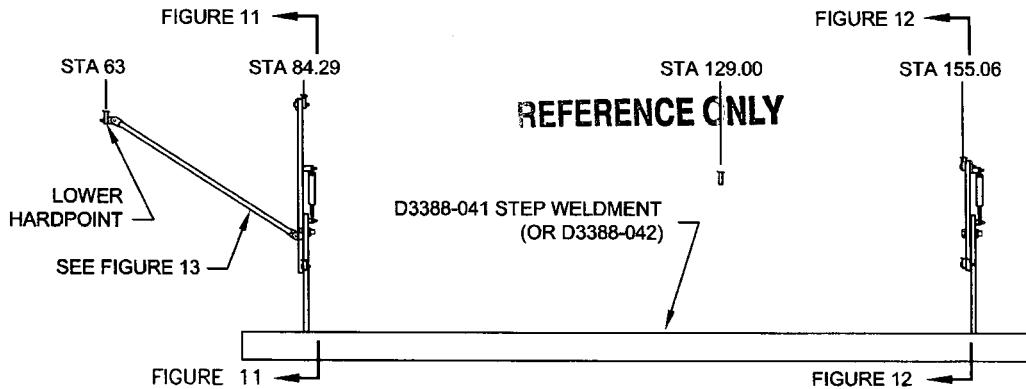
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

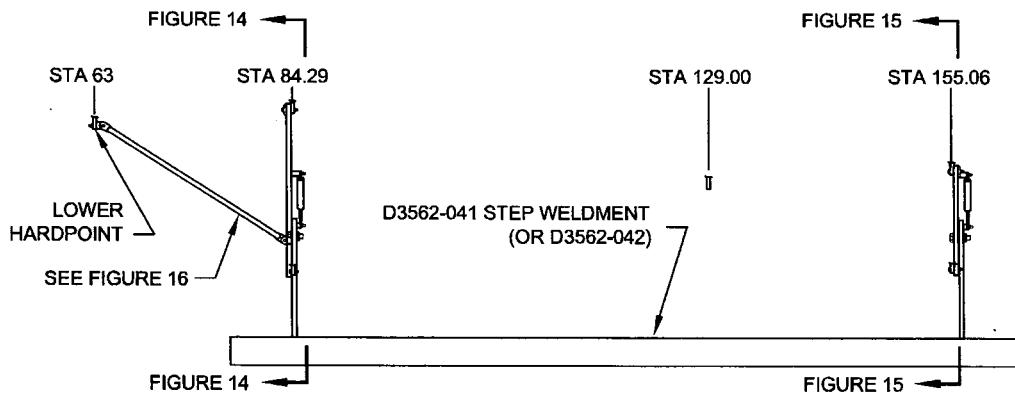
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)
D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)

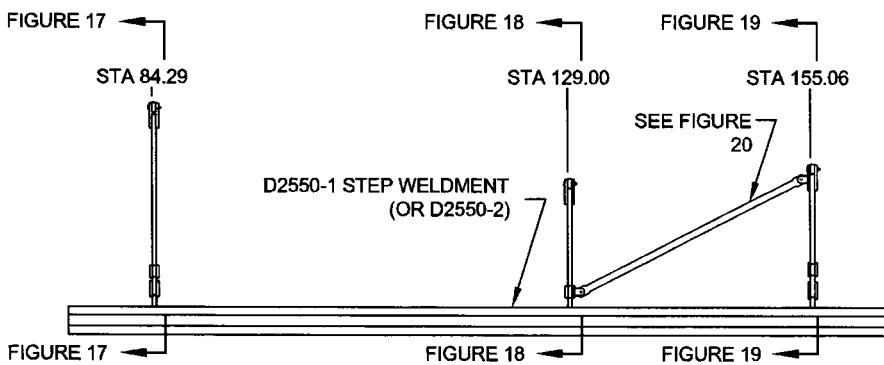


FIGURE 3 – D412-630 Heli-Access-Step™ Installations

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Revision: **M**
 Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
			1	D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)